

Date: Thursday, 14/05/2009 10:07:15 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUSSET ASS'Y
Job Number	: 47958		
Estimate Number	: 13865		
P.O. Number	:	Part Number	: D3929041
This Issue	: 14/05/2009 S.O. No. :	Drawing Number	: D3929 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: 47880	Material	:
Written By	:	Due Date	: 21/05/2009
Checked & Approved By	: <u>DD 09.05.14</u>	Qty:	<u>7</u> Um: Each
Comment	: Est Rev:A 09-04-20 new issue EC verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 0.125 Sheet
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Comment: Qty.: 0.4725 sf(s)/Unit Total : 2.8350 sf(s)  
 304/316 0.125" Sheet 1/8"  
 Batch: 11018 HB 95-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3929  
 Dwg Rev: A  
 Prog Rev: A

HB 95-15

2-Deburr if necessary

HB 95-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/05/15 (7)

5.0	D39071	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Batch: B47556 → 12 B47760 → 12P 09.05.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 14/05/2009 10:07:15 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET ASSY

Job Number: 47958

Part Number: D3929041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: m106762

*PL09.05.25* X7

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 09.05.25* ⑦

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PD 09.05.25* ⑦

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: Basket

*PD 09.05.25* ⑦

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/05/26*

Job Completion



*MF*  
*09-05-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

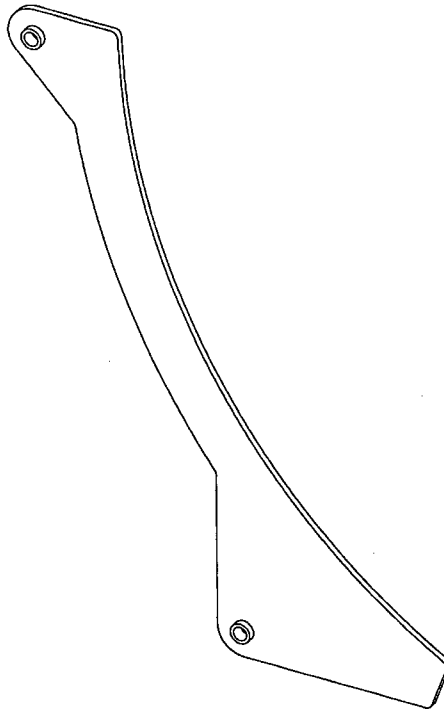
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

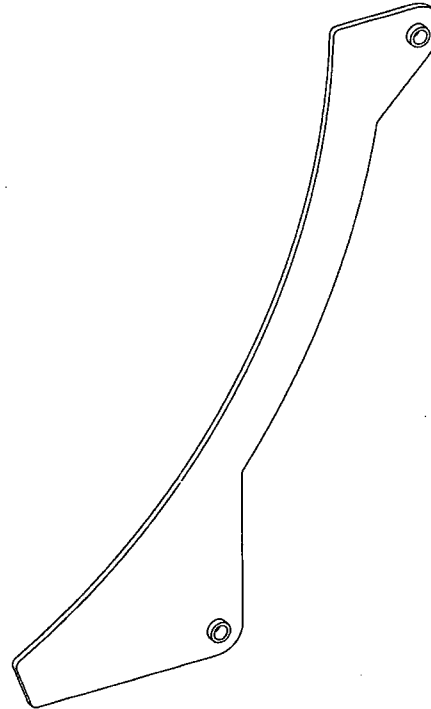
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

NO. 14758  
WORK ORDER  
SUBJECT TO AMEND.  
UNCONTROLLED  
ENGINEERING  
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- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.73 lbs EACH
  - 8) WELDING: PER DART QSI 004

**RELEASED**  
07/04/12

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN	1			
DRAWN	2			
CHECKED	3			
MFG. APPR.	4			
APPROVED	5			
DE APPR.	6			
DATE	09.04.03			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. D3929  
REV. A  
SHEET 1 OF 3  
TITLE GUSSET ASSEMBLY  
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

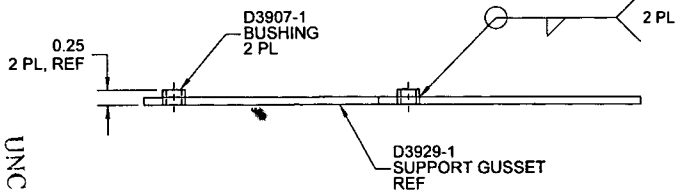
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

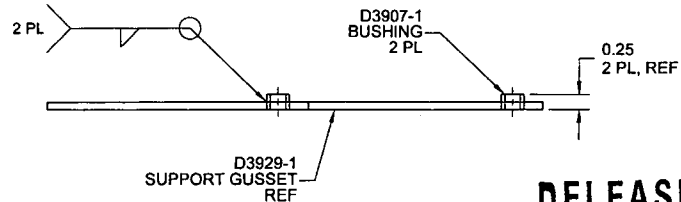
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

D3929-1  
SUPPORT GUSSET  
2 PL



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
9/16/12

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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WORK ORDER  
NO. 1158

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

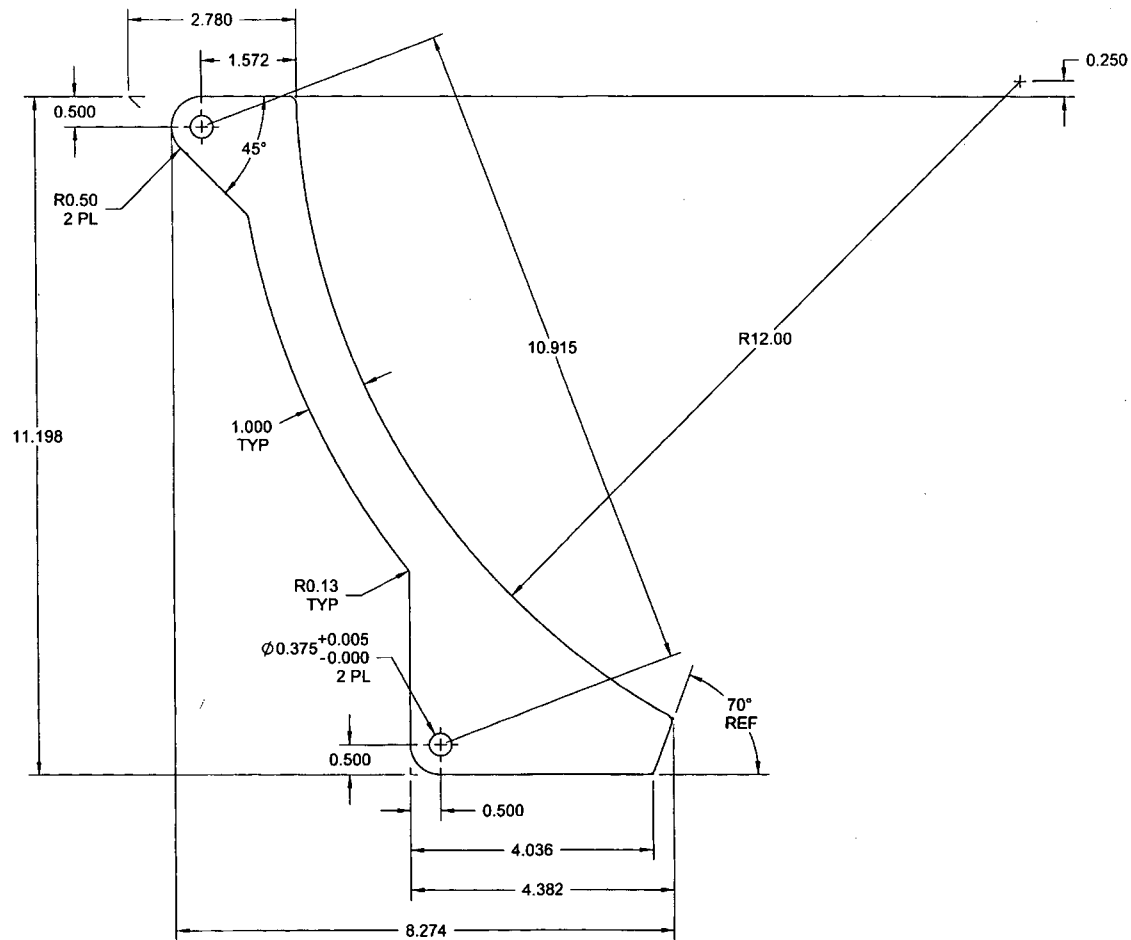
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3929-1 SUPPORT GUSSET**

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.72 lbs

**RELEASED**  
09/04/22

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>GUSSET ASSEMBLY</b>	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

